

# Work Order ID 74074

Wednesday, September 21, 2011 10:32:16 A



Page 1

Item ID:	D4154-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearplate Assembly					
Start Date:	9/21/2011	Start Qty:	6.00	Cust Item ID:		
Required Date:	9/30/2011	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-09-21	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4154	B								

100 0.00



Large Fab

Large Fab

## Memo

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

\*\*DT9756\*\*

2059 B Hardcoat Welding Rod

BATCH #: M119373

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: M117659

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

## Memo

0.00

⑥ MAL/A 11/11/24

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74074**

Wednesday, September 21, 2011 10:32:16 A



Page 2

Item ID: D4154-041  
Revision ID:  
Item Name: Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 9/21/2011 Start Qty: 6.00  
Required Date: 9/30/2011 Req'd Qty: 6.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC5- Inspect part completeness to step on W/O

0.00



QC Memo  
Quality Control

0.00

11 - 11 - 24 (6)

150

0.00



Small Fab Memo  
Small Fab

0.00

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3  
dwg D4154.

Batch 118662

11 - 11 - 24 (6)

160

QC5- Inspect part completeness to step on W/O

0.00



QC Memo  
Quality Control

0.00

Su/11/24

(76)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 74074**

Page 3

Wednesday, September 21, 2011 10:32:16 A

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 9/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: *AP-1*

0.00



Packaging

Memo

0.00

Packaging

*6 BL 11-11-25*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/11/28**MF 11-11-29*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

## Picklist Print

Wednesday, September 21, 2011 10:32:35 AM

**Work Order ID:** 74074

**Parent Item:** D4154-041

**Parent Item Name:** Wearplate Assembly

**Start Date:** 9/21/2011**Required Date: 9/30/2011****Start Qty: 6.00**

**Required Qty: 6.00**

**Comments:**

IPP Rev:A 10.09.21 new issue DD verf:EC  
10.11.04 added DT9684 DD verf:EC  
per dwg revB DD verf:EC

IPP Rev:B  
IPP Rev:C 11.04.14 as

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

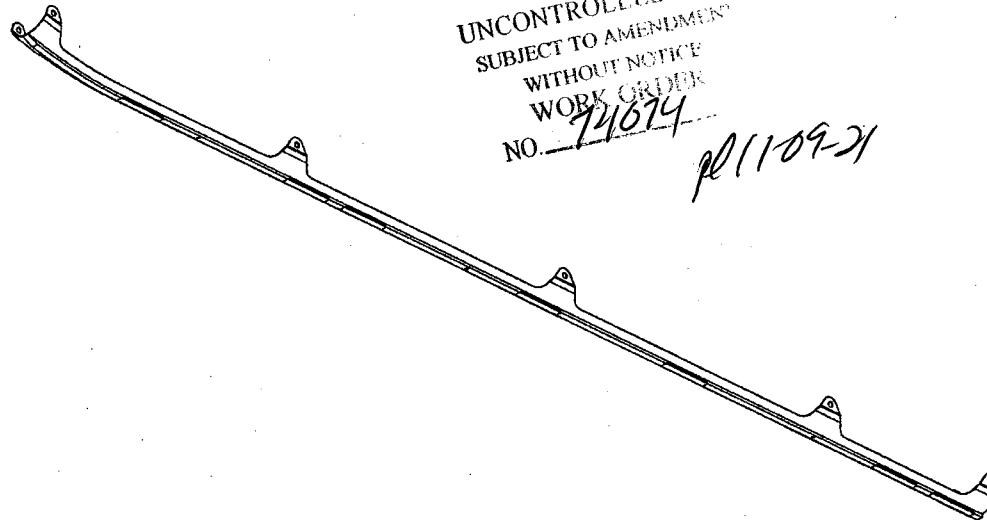
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**NOTE:** Date & initial all entries



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WITHOUT NOTICE  
WORK ORDER  
NO. 741674

*PR1109-21*



**D4154-041 WEARPLATE ASSEMBLY**

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

**RELEASED**  
R 2011-04-13

B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D4154	SHEET 1 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	11.04.05		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

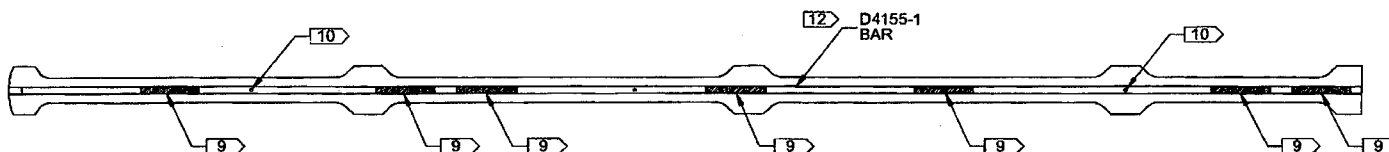
D



C



B



# **D4154-041 WEARPLATE ASSEMBLY**

**RELEASED**  
2011-04-13

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4154	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

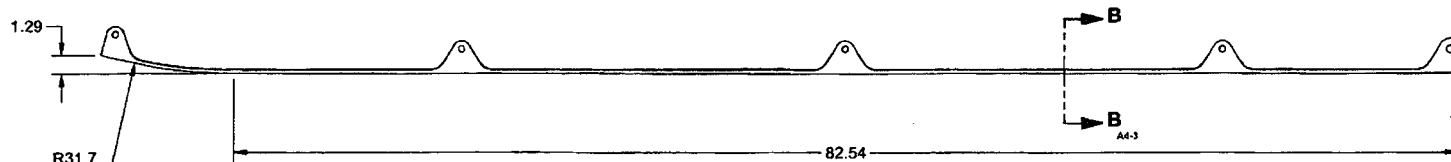
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H:\FORMS\Quality Assurance\approved QAWNCRWO RevE

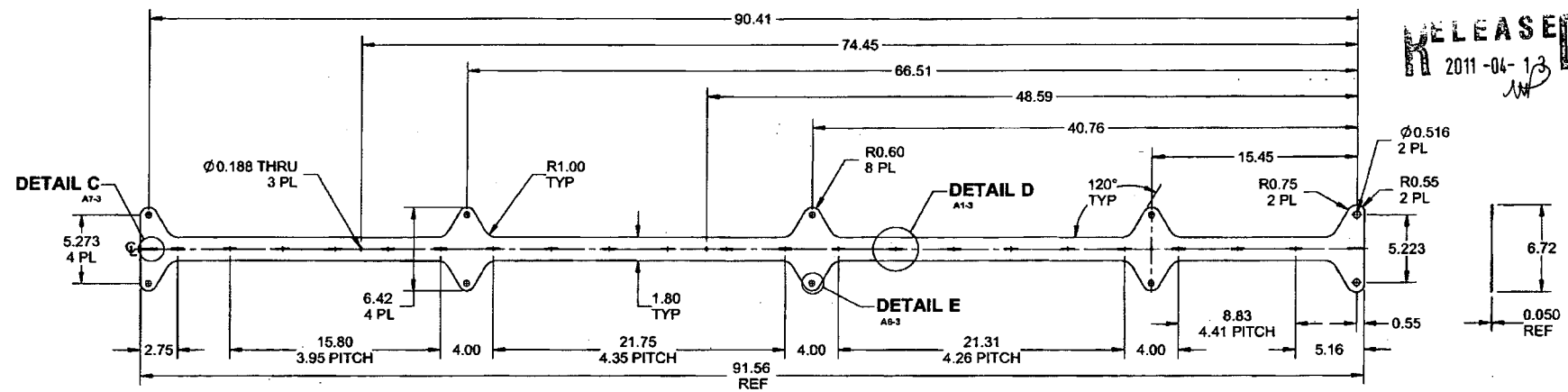
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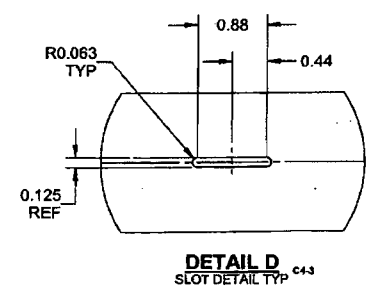
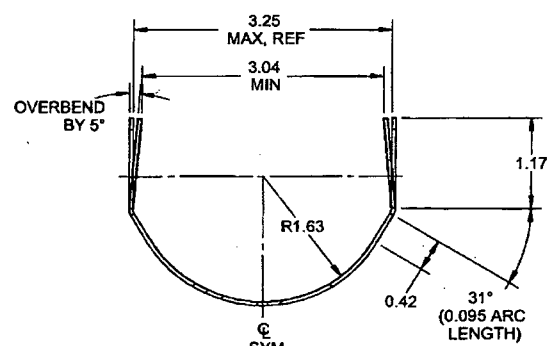
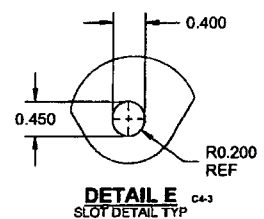
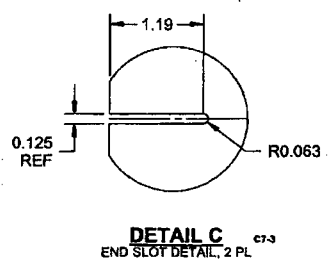
74074

**D4154-1 PLATE**  
(MAKE FROM D4154-1F)

RELEASED  
2011-04-13




**D4154-1F FLAT PATTERN**



- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
  - 2) FINISH : NONE
  - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION : NONE
  - 7) WEIGHT : 2.95 lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		D4154	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

W/O: 74074		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-11-24	100	would like to add 0.188 of length to plate 4154-1 from 15.45 to 15.638 and total length from 91.56 to 91.748 to get a perfect fit on skid tube	12	11-11-24	N/A		
		And add 0.500" to total length of bar. And welder will cut to length. These changes should make the part damn near perfect.					

Part No: D4154-041 PAR #: 11-139 Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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